

Work Order ID 66558

Tuesday, February 22, 2011 9:51:21 AM



Page 1

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 2/23/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *1/02/2011* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3535	Rev B

100



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

304.04.04

1-Cut as per Dwg D3535 Dwg Rev: *8* Prog Rev: *8* 2-
Deburr if necessary

131-2-23

13

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

131-2-23

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

131-2-23

13

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

130



Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Brake NC

Memo

0.00

SD 11/02/28

13

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form
joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-15

23/10/28

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

8/11/28

13

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Powder Coating

Memo

START TIME:

320 OF 0.00

COVEN TEMPERATURE:

□ FINISH TIME: 9:00

9:30

13x ml 11/03/01

M 115128

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Page 3

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Start Qty: 12.00



Cust Item ID:

Required Date: 3/4/2011

Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

13 4 11/03/01



QC

Quality Control

170

Identify as per dwg & Stock Location:

FP18

0.00



Packaging

Packaging

Memo

0.00

(13X) m/f 11/03/01

180

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

11/03/02 J

CL 11/03/02

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Picklist Print

Page 1

Tuesday, February 22, 2011 9:51:18 AM

Work Order ID: 66558



Parent Item: D3535-15



Parent Item Name: Wearshoe

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	111.0938	1.0205	12.89053	13.5 	18/1-2-23	

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT	111.0938	
115953	21.6	
116437	52.2538	116437
116623	37.24	

(B)

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DART AEROSPACE LTD		Work Order: <i>66535</i>
Description: Wearshoe		Part Number: D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	✗		V HB02	
2.000	+/-0.010	2.000	✗		V	
5.650	+/-0.010	5.650	✗		T HB01	
9.150	+/-0.010	9.150	✗		T	
14.400	+/-0.010	14.400	✗		T	
19.650	+/-0.010	19.650	✗		T	
24.900	+/-0.010	24.900	✗		T	
30.150	+/-0.010	30.150	✗		T	
33.650	+/-0.010	33.650	✗		T	
35.650	+/-0.010	35.650	✗		T	
39.150	+/-0.010	39.150	✗		T	
Ø0.188	+0.005/-0.001	.194	✗		V	
24.00	+/-0.030	24.00	✗		T	
16.00	+/-0.030	16.00	✗		T	
8.00	+/-0.030	8.00	✗		T	
5.00	+/-0.030	5.00	✗		T	
0.300	+/-0.010	.305	✗		V	
0.300	+/-0.010	.306	✗		V	
0.038	+/-0.010	.635	✗		V	

Measured by: <i>IB</i>	Audited by: <i>J</i>	Prototype Approval: <i>N/A</i>
Date: <i>4-2-23</i>	Date: <i>11/02/23</i>	Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM <i>✓</i>	<i>E</i>

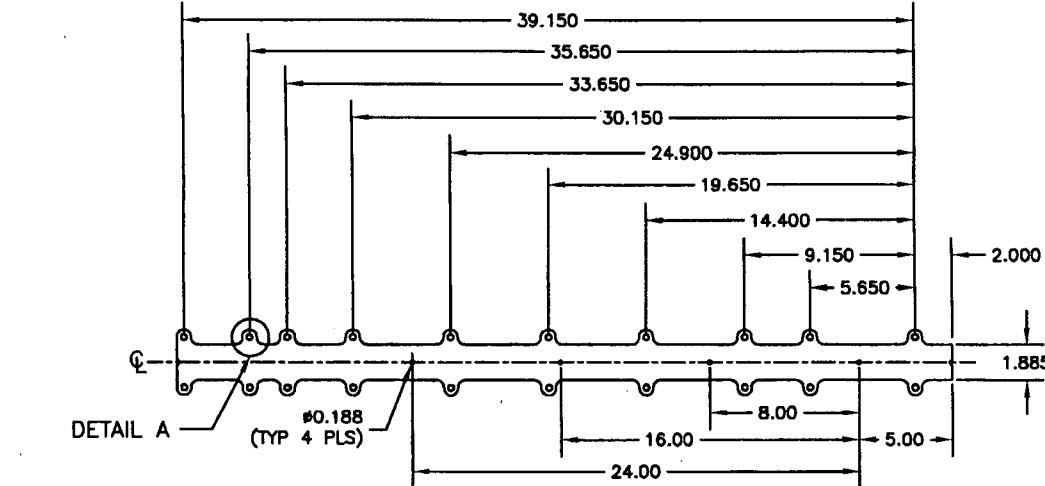
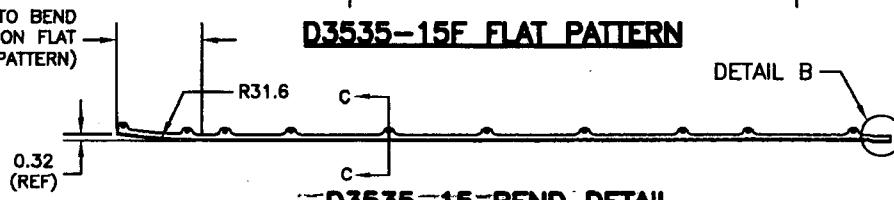
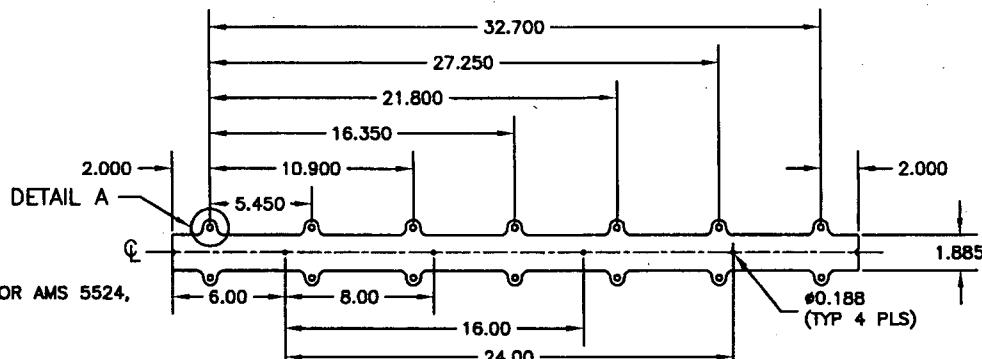
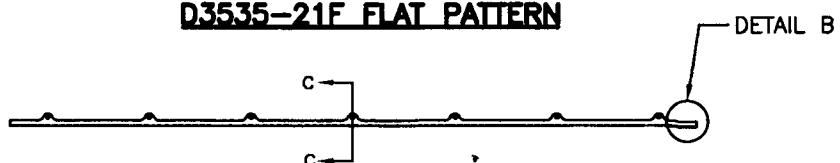
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DARTRELEASED
07.04.17**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE
		REV. B SHEET 2 OF 7 SCALE 1:10

W/O:		WORK ORDER CHANGES					
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DART

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE

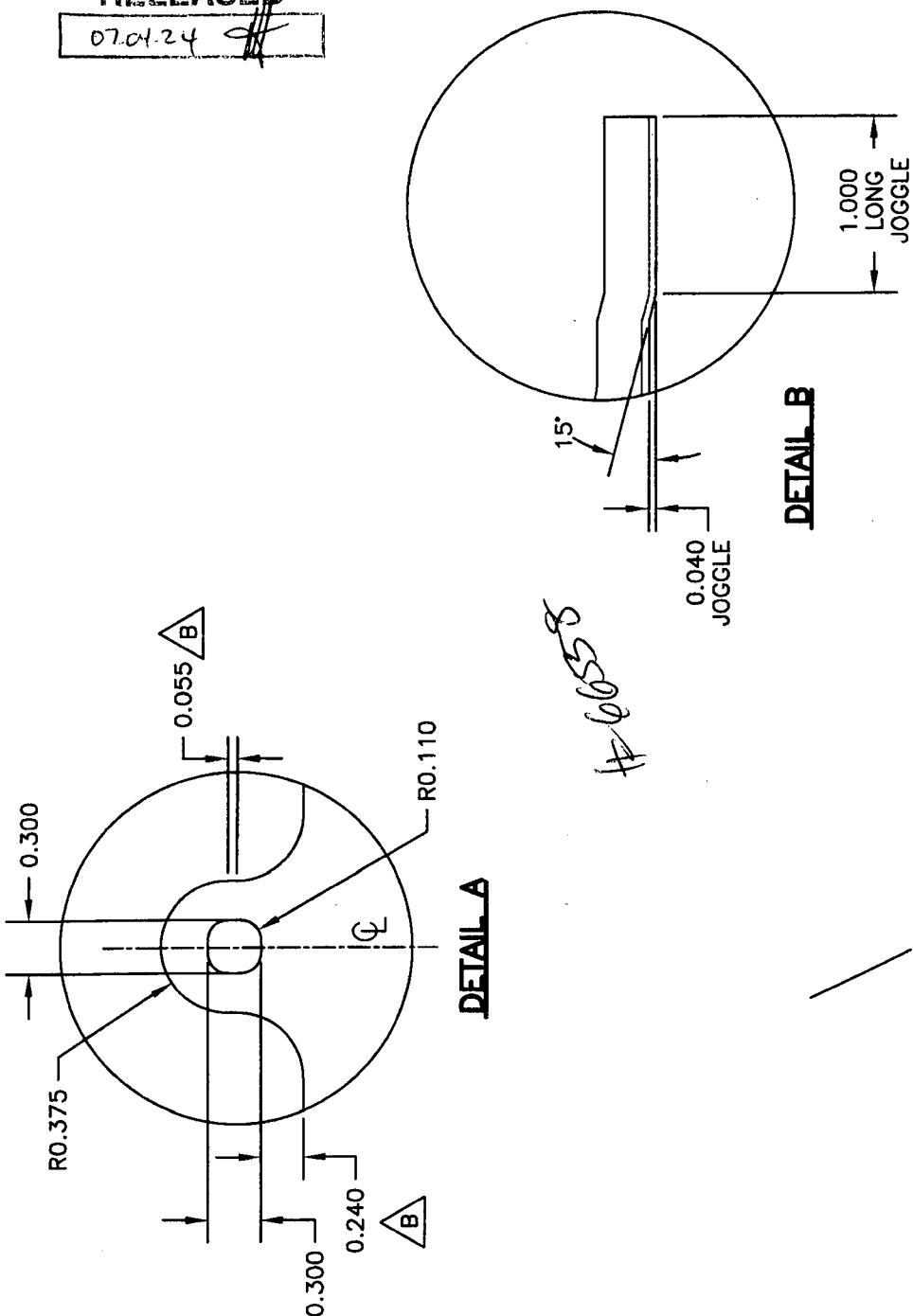
REV. B

SHEET 7 OF 7

SCALE

1:1

RELEASED

07.04.24 *[Signature]*

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